

# Work Order ID 83301

**\*83301\***

Page 1

April-16-12 4:06:06 PM

Item ID: D206-667-247TRN

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Crosstube Assembly, Mid Aft

Stop

**\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/10* Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-667-247	A

100

0.00

**\*100\***

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DTxxxx on both ends as per Folio FB030  
2-Turn first side as per Folio FB030  
3-File down transition lines smooth.  
FOLIO REV: *AA*  
DWG REV: *A*

110

QC1- Inspect dimensions to dimension sheet

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*man.L*  
*12/04/30*

*man.L*  
*12/04/30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*83301\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 16/04/2012    **Start Qty:** 1.00    **\*1\***

**Required Date:** 23/04/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Reference:**

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

**\*120\***

MORI SEIKI CNC LATHE LARGE

0.00

Mori Seiki

## Memo

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FB030  
2-File down transition lines smooth.  
3-Remove sand and plugs  
FOLIO REV: 7  
DWG REV: 0

130

QC1- Inspect dimensions to dimension sheet

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

140

QC8- Inspect parts - second check

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 83301****\*83301\***

Page 3

April-16-12 4:06:06 PM

Item ID: D206-667-247TRN

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Revision ID:

Item Name: Crosstube Assembly, Mid Aft

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Crosstubes Chemical Conversion 0.00

**\*150\***

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

*MO / JW 12-5-1*

160 QC7-Inspect Chemical Conversion Coat 0.00

**\*160\***

QC

Memo

0.00

Quality Control

*DP 12-5-1*

170 Packaging 0.00

**\*170\***

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack

Location: L/G*mm.L  
12/05/01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83301****\*83301\***

Page 4

April-16-12 4:06:06 PM

Item ID: D206-667-247TRN

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Crosstube Assembly, Mid Aft

Stop **\*NS2\***

Start Date: 16/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

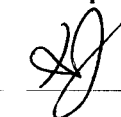
**\*180\***

QC

Memo

0.00

Quality Control

12/5/11 ME  
12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

April-16-12 4:06:46 PM

Page 1

Work Order ID: 83301

\*83301\*

Parent Item: D206-667-247TRN

\*D206-667-247TRN\*

Parent Item Name: Crosstube Assembly, Mid Aft

Start Date: 16/04/2012

Required Date: 23/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 11.01.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6004-115		Manufactured	No			100	Each	3.0000	1	1			

\*D6004-115\*

Crosstube Material

\*\*

Location

Loc Qty

Loc Code

LG

3

34685

1

38336

2

mm.l 12/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	83301
<b>Description:</b> Crosstube Assembly, Mid Aft		<b>Part Number:</b>	D206-667-247TRN
<b>Inspection Dwg:</b> D206-667-247 Rev: A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.491	/		vern
	2.025	+0.005/-0.000	2.026	/		cnc-08
	2.079	+0.005/-0.000	2.081	/		
	2.145	+0.005/-0.000	2.148	/		
	2.209	+0.005/-0.000	2.213	/		
	2.287	+0.005/-0.000	2.290	/		
	2.363	+0.005/-0.000	2.364	/		
	0.200	+/-0.010	.200	/	vern	cnc-08
	R0.063	+/-0.010	.063	/	RG	
	R2.00	+/-0.010	2.00	/	"	
	R0.063	+/-0.010	.063	/	"	
	4.438	+/-0.010	4.438	/	vern	cnc-08
SIDE B	2.490	+0.005/-0.000	2.491	/	vern	cnc-08
	2.025	+0.005/-0.000	2.026	/		
	2.079	+0.005/-0.000	2.082	/		
	2.145	+0.005/-0.000	2.149	/		
	2.209	+0.005/-0.000	2.214	/		
	2.287	+0.005/-0.000	2.291	/		
	2.363	+0.005/-0.000	2.368	/		
	0.200	+/-0.010	.200	/	vern	cnc-08
	R0.063	+/-0.010	.063	/	RG	
	R2.00	+/-0.010	2.00	/	"	
	R0.063	+/-0.010	.063	/	"	
	4.438	+/-0.010	4.438	/	vern	cnc-08
	99.76	+/-0.020	99.76	✓	tape	STARTED

<b>Measured by:</b> <i>gmm</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 12/04/30	<b>Date:</b> 12-5-1	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	11.06.21	New Issue	KJ	
B	12.02.02	Dimension 4.438 was 4.500	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## ULTRA SONIC MEASUREMENTS

Side	LOCATION on tube	R1	R2	R3	R4
A		.155	.247		
		.158	.242		
		.159	.247		
		.157	.247		

B		.172	.256		
		.168	.246		
		.160	.251		
		.156	.254		
		Part number 206-667-247			
		Batch number 83701			
		Measured By MML			

Item	Qty -247	Part Number	Description
1	X	D206-667-247	CROSSTUBE ASSEMBLY (206L MID AFT)
2	1	D6004-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2892-1	SUPPORT
6	4	D3595-063-450	RUBBER CUSHION
7	4	MS21920-22	CLAMP
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON  
INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,  
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI  
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE  
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE  
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN  
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 03301 MLG

12/04/16 DEO ATTACHED

BCW #11-615  
11.07.28

UNDER REVIEW

RELEASED  
2011-05-24

A	NEW ISSUE	CP	10.12.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D206-667-247  
TITLE CROSSTUBE ASS'Y (206L MID AFT)

REV. A  
SHEET 1 OF 4  
SCALE  
NTS

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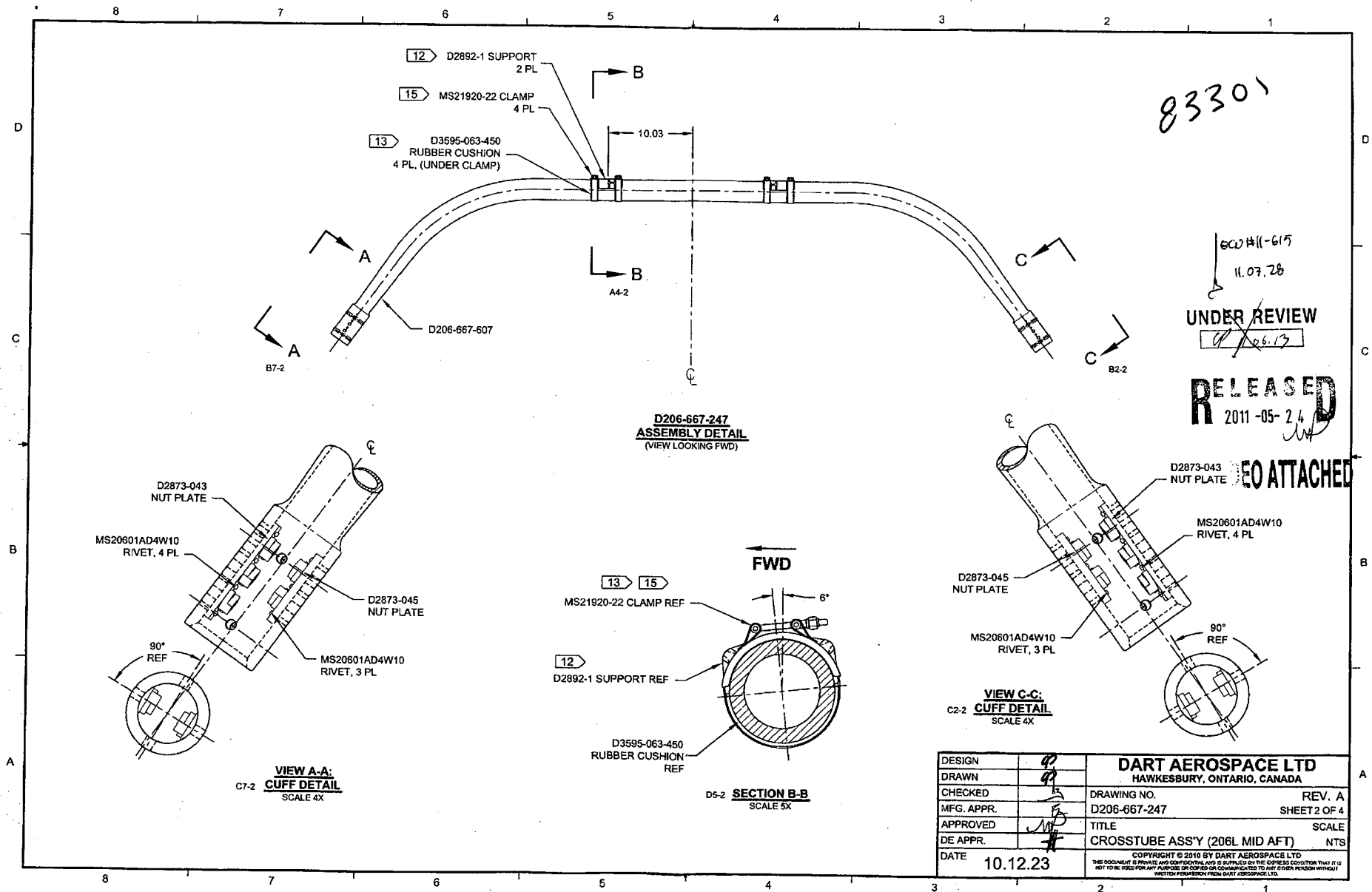
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
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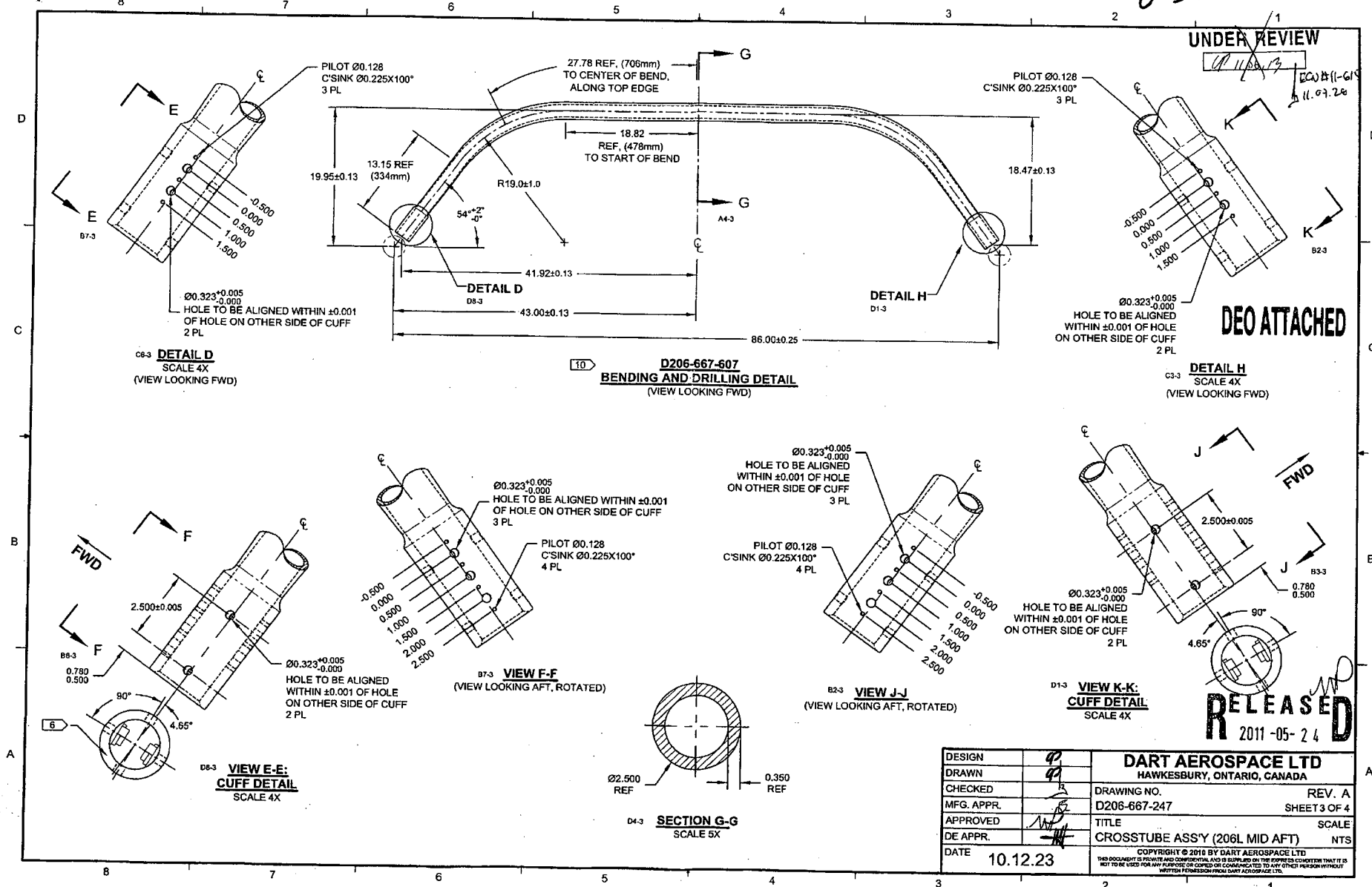
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83301

UNDER REVIEW

DEO ATTACHED

RELEASED  
2011-05-24



W/O:		WORK ORDER CHANGES					
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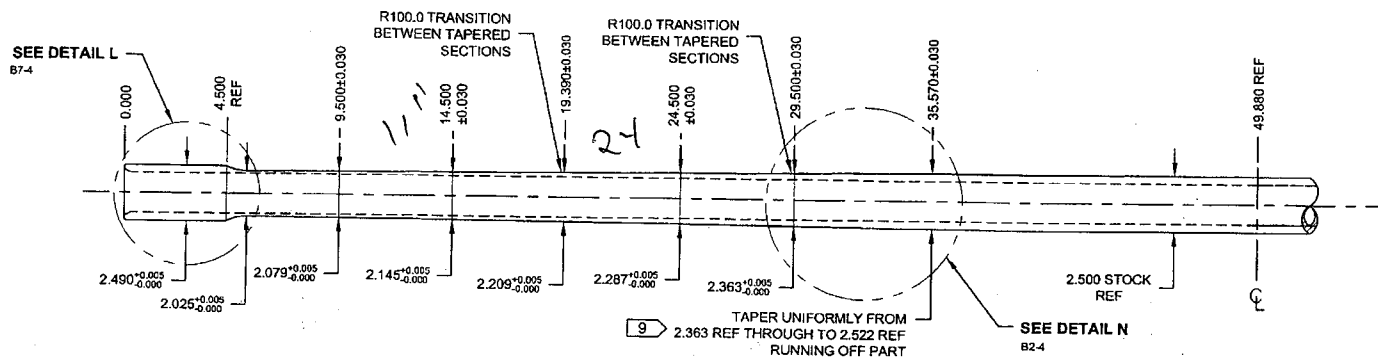
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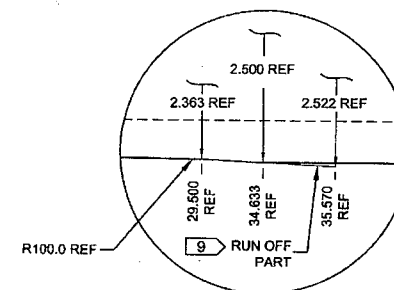
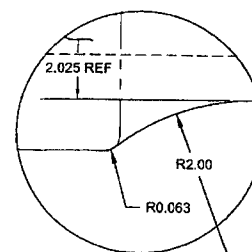
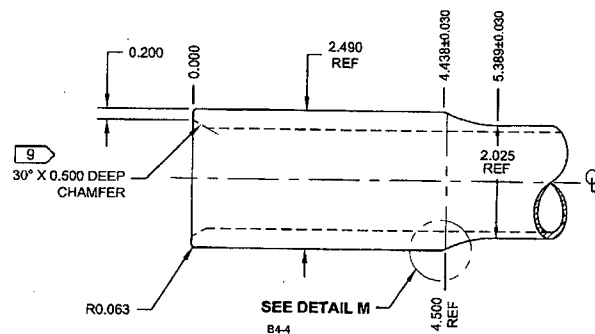
**NOTE:** Date & initial all entries

03301



0204-615  
11.07.28  
UNDER REVIEW  
11.09.13

DEO ATTACHED



RELEASED  
2011-05-24

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D206-667-247	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASS'Y (206L MID AFT)	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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**NOTE:** Date & initial all entries

03301

DRAWING NO. D206-667-247	TITLE CROSSTUBE ASS'Y (206L MID AFT)	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>	D.E.O. NO. D206-667-247-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 9	CHECKED ASS	MFG. APPR. KTB	APPROVED JMD	DE APPR. H		
DATE 11.07.15	DATE 11.07.20	DATE 11.07.21	DATE 11/07/21	DATE 11.07.21		

**PURPOSE:**

REPLACE MAGNOBOND WITH PROSEAL

**CHANGE:**

**IS:**

Item	Qty -247	Part Number	Description
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

**WAS:**

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

**IS:**

- 12) TO INSTALL D2892-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

**WAS:**

- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED  
2011-07-28  
JMD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries